

Date: Monday, 10/16/2006 2:01:28 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B HIGH GEAR WEB
Job Number : 29008	
Estimate Number : 10455	
P.O. Number : NIA	Part Number : D26543
This Issue : 10/16/2006 S.O. No. : NIA	Drawing Number : D2654 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : LANDING GEAR	Drawing Revision : E1
Previous Run : 28403	Material : NIA
Written By : <u> </u>	Due Date : 10/30/2006 Qty: 8 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedure DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2600-5	Web

Batch

324410 RT/06-10-17 (8)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

RT 06-10-17 (8)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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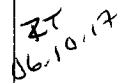
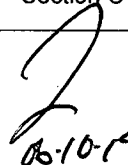


**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.R 06/10/18 (8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 04/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-19	2.1	Welds were cut too 80.08, instead of 80.80. Human error by reaching the measurement wrong.		Parts are acceptable As per E-mail.	 06-10-19	 06-10-19		 16-10-19

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:01:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 29008

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



pm 06-10-20



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LC*

pm 06-10-20



7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DD 06/10/20

Job Completion



LC 06-10-20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	






Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

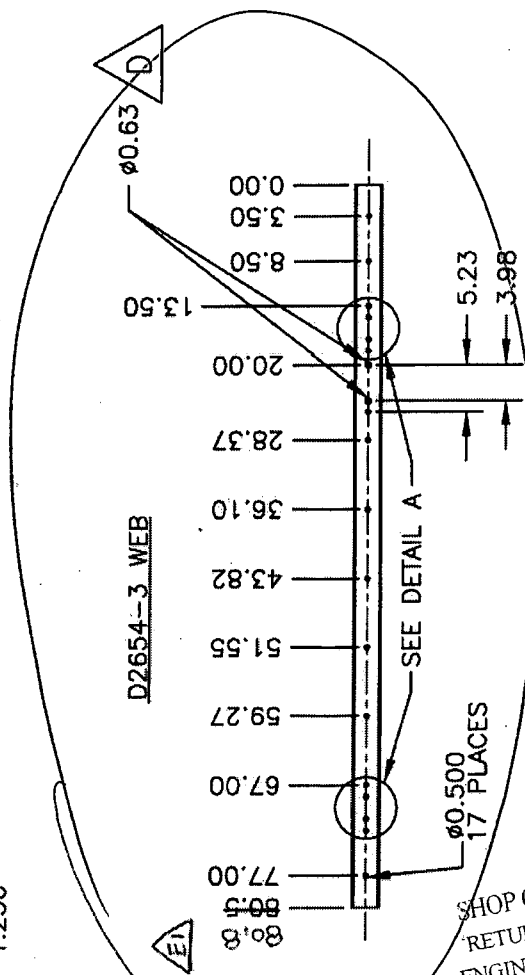
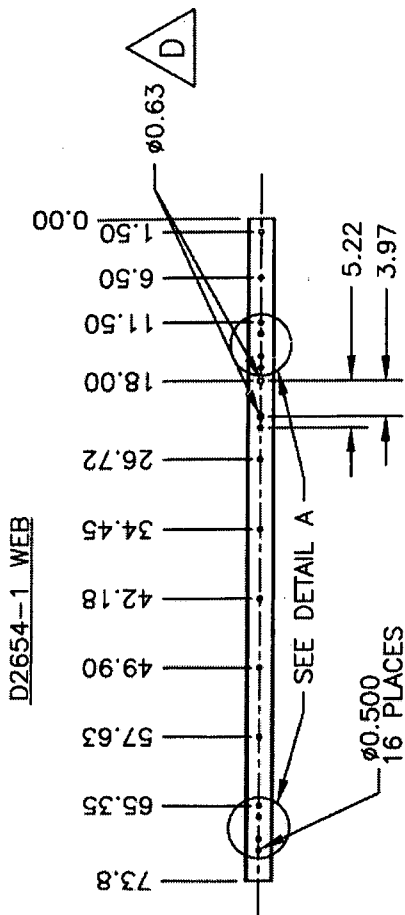
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26				TITLE WEB	SCALE 1:20
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO Ø0.63		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	 04.08.04		PER TOOLING; 80.8 WAS 80.5		

RELEASED
04.06.22



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MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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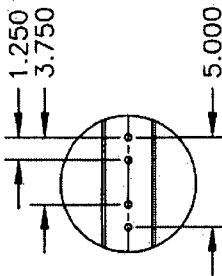
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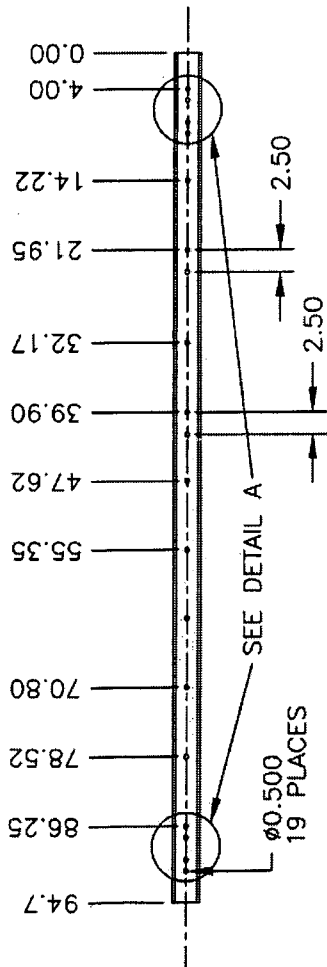
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED
04.06.22

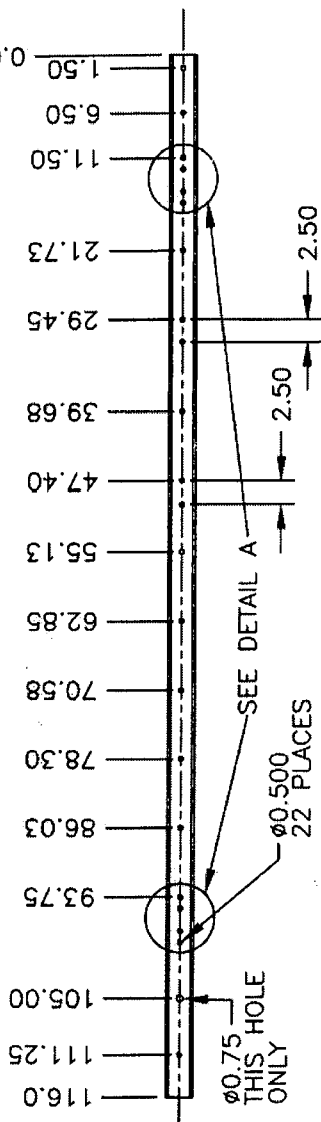
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, October 19, 2006 10:24 AM
To: 'Chris Provencal'
Cc: 'Jason Murdoch'; 'L Lacelle'
Subject: RE: NCR D2654-3 WEB

Chris/Jason,

Unless you see a problem, I think these parts are acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, October 18, 2006 11:22 AM
To: David Shepherd (David Shepherd)
Cc: 'Jason Murdoch'
Subject: NCR D2654-3 WEB

Qty(8) D2654-3 Webs for the D2650-3 Skidtube: They misread the dwg, they cut the total length to 80.08" instead of 80.8" . They are too short on the fwd end, and all the holes have been drilled. Are these parts acceptable?

-Chris

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No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.5/483 - Release Date: 10/18/2006

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No virus found in this outgoing message.
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Version: 7.1.408 / Virus Database: 268.13.5/483 - Release Date: 10/18/2006

10/19/2006

